

Date: Monday, 12/05/2008 10:02:11 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : INNER FWD SADDLE
<b>Job Number</b> : 39197	
<b>Estimate Number</b> : 11079	
<b>P.O. Number</b> :	<b>Part Number</b> : D5953
<b>This Issue</b> : 12/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D5953 REVB
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 38366	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 05/06/2008 <b>Qty:</b> 2 / Um: Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.5.12</u>	
<b>Comment</b> : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:f ecn 826 06.12.06 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101007	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 D6101-007(7075-T7351)  
 Size 2.50" x 7.50" X 8.25" (Grain along 7.50")  
 Batch: 3 34375

*8.8 08/05/27*

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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**Comment:** HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5953, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr &amp; Tumble

*8.8 08/05/27*

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

*8.8 08/05/28*

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*SA 08/05/28*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

*M. J. RD 08/05/28*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:02:12 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER FWD SADDLE

Job Number: 39197

Part Number: D5953

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



*W/107892*



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

*11:55*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*12:25*

*FL 08/05/28*

*(3)*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-L 08/05/28*

*(2x)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*C 08/05/28*

*(2)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/05/28*

Job Completion



*mf 08-05-28*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39197
<b>Description:</b> Inner Fwd Saddle		<b>Part Number:</b> D5953
<b>Inspection Dwg:</b> D5953	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.443	.443				
B	1.745	1.755		1.748	1.748				
C	5.245	5.255		5.247	5.250				
D	6.995	7.005		7.004	7.002				
E	5.240	5.260		5.249	5.250				
F	4.745	4.755		4.749	4.750				
G	0.315	0.322		.320	.322				
H	1.522	1.532		1.526	1.526				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.580	4.580				
K	0.313	0.318		.318	.318				
L	0.495	0.505		.500	.500				
M	0.490	0.510		.505	.504				
N	1.615	1.635		1.625	1.625				
O	7.990	8.010		7.994	7.995				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		.310	.310				
R	0.760	0.765		.760	.760				
S	0.490	0.510		.495	.495				
T	1.375	1.395		1.383	1.383				
U	2.000	2.020		2.001	2.001				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

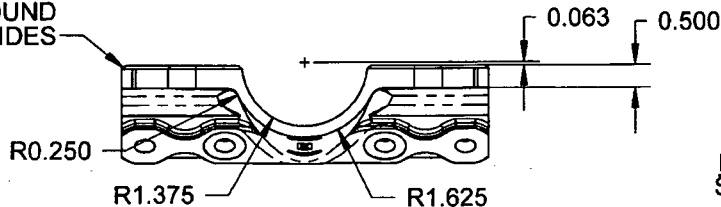
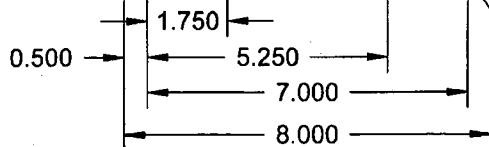
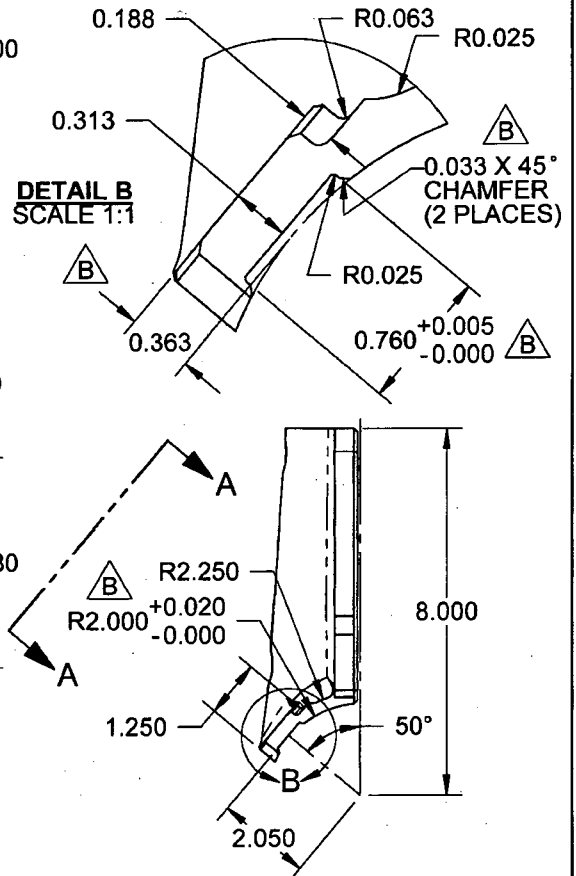
Measured by: <u>SS</u>
Date: <u>05/05/27</u>

Audited by: <u>SA</u>
Date: <u>08/05/28</u>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D5953</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>INNER FWD SADDLE</b> SCALE 1:4		
REV	DATE	DESCRIPTION	
A	97.05.06	NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

RELEASED  
06.11.28CHAMFER  
0.075 X 45°  
ALL AROUND  
BOTH SIDESENGRAVE PART NO.  
AND BATCH NO.  
WITH MIN RAD OF  
0.010 TO MAX  
DEPTH OF 0.010R0.500  
 $\phi 0.316$   
(8 PLACES)DRILL  $\phi 0.316$  THRU  
 $\phi 0.750$  SPOT FACE  
(2 PLACES) $\phi 0.920$  SPOT FACE  
(2 PLACES)GRAIN  
DIRECTIONR0.660  
 $\phi 0.438$   
(4 PLACES)**VIEW A-A**0.040 X 45° CHAMFER  
ALL AROUND**D5953 INNER FWD SADDLE**SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39197**ISOMETRIC VIEW**  
SCALE 1:8**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED  
BREAK ALL SHARP EDGES 0.010 TO 0.020

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